

Work Order ID 79328

Wednesday, January 25, 2012 12:49:07 PM

79328

Ship Feb. 3rd Page 1

Item ID: D206-642-611

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Float Skidtube LH

Start Date: 1/24/2012 Start Qty: 1.00

1

Required Date: 1/31/2012 Req'd Qty: 1.00

1

Reference: REWORK

Cust Item ID:

Customer:

DART				TEL: 1-613-632-3336	
TRANSPORT CANADA APPROVAL #09-89				FAX: 1-613-632-4443	
PN	D206-642-611	CHG	CHG003		
DESC	Float Skidtube LH	STC	SH98-4		
LOT	B35179	STC	SA00475SE		
MODEL	Bell 206A/B	STC			
US PATENT # 5735484				MADE IN CANADA	
CANADA FOREIGN PATENTS PENDING					

Approvals: Process Plan: *MF*

Date: *12-25* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D206-642	0

150

0.00

150

HandFinish

Hand Finishing

Memo

0.00

PULL FROM STOCK D206-642-611 B 35179

chg003

REMOVE CAP AND WASH LPS3 ENTIRELY OUT OF TUBE PER ECN 09-616

12-01-30 (1)

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Quality Control

Memo

0.00

12-01-31 (1)

B79328 D206-642-611

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Wednesday, January 25, 2012 12:49:07 PM

Item ID: D206-642-611

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Float Skidtube LH

Start Date: 1/24/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/31/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference: REWORK

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
170									
HandFinish	Memo	0.00							
Hand Finishing	4-RE-ASSEMBLE I D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive. A/RSikaflex-291 <u>119508</u> Sikaflex expire date: <u>12/08</u>								
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									
190	Pick Kit	0.00							
190									
Packaging	Memo	0.00							
Packaging	REMOVE D3672-5 X 16 AND REPLACE WITH D3672-7 X 16 PER DSI 9467 (ECN 09-616)								

AB 12 - 1 - 31

12 : 01 : 31 (1)

12/1 sf

Work Order ID 79328

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Wednesday, January 25, 2012 12:49:07 PM

Item ID: D206-642-611

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Float Skidtube LH

Start Date: 1/24/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/31/2012 Req'd Qty: 1.00

1

Customer:

Reference: REWORK

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC4- 100% Inspect kits for completeness

0.00

200

QC

Memo

0.00

Quality Control

210

Identify as per dwg & Stock Location: FGA

0.00

210

Packaging

Memo

0.00

Packaging

ID AND STOCK UNDER NEW BATCH NUMBER AND NEW CHANGE
NUMBER chg 004

ADD NEW PAPERWORK

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

SP 12-02-01

M.C.J. 12/02/01

R12-02-1

Picklist Print

Wednesday, January 25, 2012 12:49:06 P

Page 1
1

Work Order ID: 79328

Parent Item: D206-642-611

Parent Item Name: Float Skidtube LH

Start Date: 1/24/2012

Required Date: 1/31/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B05.10.27Revised pick listKJ/EC
IPP Rev:C 07-12-05 ECN 1080p Rev:L DD verified by:ec
IPP Rev:D 09-01-06 update part list DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3672-5 Phenolic Washer		Manufactured	No				Each	1,864.0000		-16			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST060		1864							
				35521		1075			16				
				44679		220							
				50354		569							
D3672-7 Phenolic Washer		Manufactured	No				Each	1,068.0000		1261.18			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST060		1068			16				
				73488		68							
				76279		1000							

Qty -041	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2646	AFT CAP
1	D2647	CAP
9	D2649	CROSS BOLT SPACER
6	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
12	D3683-1	INSERT
64	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN4C5A	BOLT
1	AN960C416	WASHER
78	AN960C10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
12	MS27039C1-05	SCREW (or AN3C3A BOLT)
2	NAS1515H3L	WASHER

GENERAL NOTES:

1. MATERIAL: N/A
2. FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
3. TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4. UNITS: INCHES UNLESS OTHERWISE NOTED
5. BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6. IDENTIFICATION: NONE
7. WEIGHT: 20.8 LBS
8. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
9. BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
10. ALL HOLES DRILLED ON CENTERLINES EXCEPT WHERE SHOWN
11. DRILL 20.297 HOLES FOR D3683-1 INSERTS BEFORE FINISH. INSTALL D3683-1 INSERTS AFTER FINISH
12. DRILL 20.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291
13. WELDING: PER DART QSI 004
14. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
09/06/17

G	REFORMAT DWG, RMV LPS-3 (ZN B6-3) RMV C'BORE & ADD SECTION K-K (ZN C2-4)	CP	09.06.17
F	SUBSTITUTE FLOAT BAG INSERT W/SPEC CTRL DWG WAS ALS7-1032-130, IS NOW D3683-1	DC	07.11.21
E	MID-FLOAT HOLES WERE MOVED 2.00" FWD AND ROTATED INBOARD AND OUTBOARD BY 17° INSERTS ARE NOW INSTALLED AT THESE LOCATIONS	MB	07.09.14
D	DIMENSIONS ADDED	DC	07.06.04
C	NEW INSERTS, SS WEARSHOES AND GASKETS	PH	06.12.19
B	CHANGE INSERTS	CP	05.03.18
A	NEW ISSUE	CP	04.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.17		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3288 REV. G
SHEET 1 OF 4

TITLE SKIDTUBE ASSEMBLY SCALE NTS

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#79328

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.9 206A/B HIGH GEAR FLOAT SKIDTUBES, TRI-BAG COMPATIBLE (D206-642)
 32.19 206A/B HIGH GEAR FLOAT SKIDTUBES, TRI-BAG COMPATIBLE (ICA-D206-642)

ITEM	QTY -611	QTY -612	QTY -613	QTY -614	QTY -641	QTY -654	PART NUMBER	DESCRIPTION
	X						D206-642-611	SKIDTUBE INSTALLATION, LH
		X					D206-642-612	SKIDTUBE INSTALLATION, RH
			X				D206-642-613	SKIDTUBE INSTALLATION, LH, THRU BOLT
				X			D206-642-614	SKIDTUBE INSTALLATION, RH, THRU BOLT

IS:

12B	16	16	16	16			D3672-7	WASHER
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WAS:

12B	16	16	16	16			D3672-5	WASHER
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82962 #

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	CP	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9467	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WASHER CHANGE	NTS
DATE	09.06.17	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79328

Wednesday, January 25, 2012 12:49:07 PM

Item ID: D206-642-611

Revision ID:

Item Name: Float Skidtube LH

Start Date: 1/24/2012 Start Qty: 1.00

Required Date: 1/31/2012 Req'd Qty: 1.00

Reference: REWORK

Approvals: Process Plan: MF

QC:

Date: 12-01-25 Tooling:

Date: SPC (Y/N):

Sequence ID/
Work Center ID

Operation
Description

Draw Nbr

Revision Nbr

IIN D206-642

O

150

150

HandFinish

Hand Finishing

Memo

PULL FROM STOCK D206-642-611 B 35179

REMOVE CAP AND WASH LPS3 ENTIRELY OUT OF TUBE PER ECN 09-616

160

160

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Accept

1

1

79328

N900040100

Setup Start *NS1*

Cust Item ID:

Customer:

Date:

Date:

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

12/01/13

12-01-10

12-01-31

DART				TEL: 1-613-632-33	
TRANSPORT CANADA APPROVAL # 09-89				FAX: 1-613-632-44	
P/N	D206-642-611	CHG	CHG003		
DESC.	Float Skidtube LH	STC	SH98-4		
LOT	B35179	STC	SA00475SE		
MODEL	Bell 206A/B	STC			
US PATENT # 5735484				MADE IN CANADA	
CANADA FOREIGN PATENTS PENDING					

NR2

12-01-31